

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009312**Date Inspected:** 14-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Ying Xin, Du Zhi Qun.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

Bay 10 North Tower Lift 3 skin D cover plate with web plate

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% and Visual Testing (VT) of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT reports for this date. The members are identified as Tower Components. The weld designations reviewed are as follows.

NSTL3-3C/K-70, 83

NSTL3-3G/K-85, 73

NSTL3-3I/K-74, 73

Bay 10 South Tower Lift 4 skin D with stiffeners

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% and Visual Testing (VT) of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT reports for this date. The members are identified as Tower Components. The weld designations reviewed are as

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follows.

SSD1-FDSA4-1C/C-15A/B, 30A/B, 53A/B, 42A/B (MT & VT)

SSD1-FDSA4-1C/C-1A/B, 16A/B, 56A/B, 31A/B (VT only)

This Quality Assurance (QA) Inspector issued green tag for the following parts:

South Tower Lift 4 skin D with stiffeners: Green Tag No. 9838

South tower lift 4 gusset plate between stiffeners of skin D: Green Tag No. 9837

Strut plate WD1-A467-23M-4 Green Tag No. 6743R1 changed to 6734R1. (Refer report on dated 09/08/2009)

Bay 10

STRUT PLATE

SMAW welding of weld joint 12B located on ND1-A6002-13.

Welder is identified as 050289. ZPMC QC is identified as Mr. Chen Ying Xin.

The welding variables recorded by QC appeared to comply with WPS-B-T-2212-Tc-U5b.

SMAW welding of weld joint 33 located on ED1-A6003-3.

Welder is identified as 037779. ZPMC QC is identified as Mr. Chen Ying Xin.

The welding variables recorded by QC appeared to comply with WPS-B-T-2112.

SOUTH TOWER INTERIOR SPLICE PLATE

FCAW welding of weld joint 3B located on SSD1-SPSA3-70.

Welder is identified as 053870. ZPMC QC is identified as Mr. Du Zhi Qun.

The welding variables recorded by QC appeared to comply with WPS-B-T-2231-Tc-U5-F-1.

NORTH TOWER LIFT 4 SKIN A DOUBLER PLATE

FCAW welding of weld joint 8 located on NSD1-FASA4-1C/E.

Welder is identified as 040345. ZPMC QC is identified as Mr. Yuan Wei Jie.

The welding variables recorded by QC appeared to comply with WPS-B-T-2332-Tc-P4-F-2.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Jim Simonis - 134-7246-3441, who represents the Office of Structural Materials for

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your project.

Inspected By: Gaikwad,Umesh

Quality Assurance Inspector

Reviewed By: Clifford,William

QA Reviewer